

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-030029**Date Inspected:** 03-Sep-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Bernie Docena**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS Tower**Summary of Items Observed:**

Caltrans Office of Structural Material (OSM) Quality Assurance Inspector (QAI) Joselito Lizardo was present at the Self Anchored Suspension (SAS) job site as requested to perform observations on the welding of components for the San Francisco Oakland Bay Bridge (SFOBB) Project.

At the Tower Base Electro Slag Weld (ESW) welding repair, this QA took over from fellow QA Edward Leach the welding repair observations due to appointment Mr. Leach has to attend. This QA randomly observed ABF welding personnel Mike Jimenez continuing to perform the welding repair utilizing the Shielded Metal Arc Welding (SMAW) process in the vertical (3G) position with Atom Arc E7018-1 H4R, 5/32" diameter electrode to weld cover passes for weld repair. The welding is taking place on the exterior (west) side at joint T, weld #S-043 on Face B side for a repair designated as 201308-004. Excavation dimensions are noted as Y=4100mm-4410mm, Length=310mm, Width=68mm, Depth=70mm. The QAI observed the interpass temperature was maintained at approximately 350 degrees Fahrenheit using Miller Proheat 35 Induction Heating System. The QAI verified interpass temperature with a thermal heat gun. As welding continued the QAI periodically verified welding parameters at approximately 150 amperes per ABF-WPS-D1.5-ESW-80-100TR. The welder was also observed using proper interpass cleaning methods with a slag hammer and a wire brush. QC Inspector Bernie Docena was noted monitoring the progress of this repair on this date. Welding was still continuing when the power was interrupted and the welder was cut short of their duty to eight hours. The welder performed the post weld heat treatment after welding using the propylene torch for approximately three hours.

The welding & workmanship observed on this date appeared to be in general compliance with the contract specifications.

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At Tower Electro Slag Weld (ESW) T-Joint 6 (S-043) welding repair, ABF personnel were noted using the Miller ProHeat 35 Induction Heating System to preheat and maintain the required preheat temperature of 350 degrees Fahrenheit.



Summary of Conversations:

No significant conversation occurred today.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Gary Thomas 916-764-6027, who represents the Office of Structural Materials for your project.

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| Inspected By: | Lizardo, Joselito | Quality Assurance Inspector |
| Reviewed By: | Reyes, Danny | QA Reviewer |
